IN THE CLAIMS:

Please amend the claims as follows:

1. (Currently Amended) A method for preparing a tube end for a welding operation, comprising the steps of:

utilizing a rotary milling tool having a first milling head to remove a predetermined amount of radial thickness from the outer diameter of said tube to a predetermined depth; and

beveling the end of said tube utilizing said rotary milling tool, wherein the first milling head comprises a cylindrical body having an annular recess, said body adapted to be connected to a rotary milling tool, and one or more cutting blades connected to said body by a securing element, each said blade disposed circumferentially around the rotational axis of the milling head, each said blade having a cutting edge defining an annular cutting sweep having an inner radius which is adapted to remove an outer radial thickness from said tube in an amount of from about 2% up to about 25% of said annular tube thickness, and an outer radius at least equal to said tube outer diameter.

2. (Original) A method according to claim 1, further including the step of removing a membrane adjacent said tube end, or a weld overlay adjacent said tube end, or a combination thereof to a predetermined depth.

3. (Original) A method according to claim 1, further including the step of removing a weld overlay from a front portion or a back portion of said tube, or a combination thereof, with said first milling head to a predetermined depth either simultaneously with or after said tube radial thickness removal step.

4. (Currently Amended) A method according to claim 1, wherein from about 2% up to about 25% of said tube radial thickness is removed during said tube diameter removal step, **[[and]]** wherein said tube diameter removal step is performed to a depth of from about 0.25 to about 1.5 inches when measured from said tube end, and wherein the first milling head blade has a face surface and an opposite surface with a bore extending

therebetween through which said securing element connects said blade to said body, said blade having a countersink around said bore capable of receiving at least a portion of a head of said securing element.

5. (Original) A method according to claim 3, wherein from about 2% up to about 25% of said tube radial thickness is removed during said tube diameter removal step, and wherein said tube diameter removal step is performed to a depth of from about 0.25 to about 1.5 inches when measured from said tube end.

6. (Currently Amended) A method according to claim 4, wherein up to about 10% of said tube radial thickness is removed, **[[**and**]]** wherein said depth is from about 0.25 to about 1 inch, and wherein said securing element connects said blade to said body whereby the securing element head portion has an end which is flush mounted or recess mounted in relation to said blade face.

7. (Original) A method according to claim 5, wherein up to about 10% of said tube radial thickness is removed, and wherein said depth is from about 0.25 to about 1 inch.

8. (Currently Amended) A method according to claim**[[**2**]]** 4, wherein said beveling step is performed with a second milling head and said membrane removal is performed with a third milling head, and wherein said securing element connects said blade to said body whereby the securing element has a head portion which extends out from said blade face surface a first distance which is less than or equal to a second distance measured from a lower edge of the securing element head to a lower cutting edge of the blade.

9. (Original) A method according to claim 8, wherein up to about 25% of said tube radial thickness is removed during said tube diameter removal step, and wherein said tube diameter removal step is performed to a depth of from about 0.25 to about 1.5 inches when measured from said tube end.

10. (Currently Amended) A rotary milling head for a rotary milling tool, comprising:

a cylindrical body having an annular recess, said body adapted to be connected to a rotary milling tool;

one or more cutting blades connected to said body by a securing element, each said blade disposed circumferentially around the rotational axis of the milling head, each said blade having a cutting edge defining an annular cutting sweep having an inner radius which is adapted to remove an outer radial thickness from an annular tube in an amount of from about 2% up to about 25% of said annular tube thickness, and an outer radius at least equal to said tube outer diameter, and wherein said blade has a face surface with a bore extending therethrough through which said securing element connects said blade to said body, said blade having a countersink around said bore capable of receiving at least a portion of a head of said securing element.

11. (Cancelled).

12. (Currently Amended) A milling head according to claim **[[**11**]]** 10, wherein said securing element connects said blade to said body whereby the securing element head portion has an end which is flush mounted or recess mounted in relation to said blade face.

13. (Currently Amended) A milling head according to claim **[[**11**]]** 10, wherein said securing element connects said blade to said body whereby the securing element has a head portion which extends out from said blade face surface a first distance which is less than or equal to a second distance measured from a lower edge of the securing element head to a lower cutting edge of the blade.

14. (Original) A milling head according to claim 12, wherein said blade cutting sweep inner radius is from about 2% to about 15% of said annular tube thickness.

15. (Original) A milling head according to claim 13, wherein said blade cutting sweep inner radius is from about 2% to about 15% of said annular tube thickness.

16. (Original) A milling head according to claim 12, wherein said blade cutting sweep inner radius is from about 2% to about 10% of said annular tube thickness.

17. (Original) A milling head according to claim 13, wherein said blade cutting sweep inner radius is from about 2% to about 10% of said annular tube thickness.

18. (Currently Amended) A milling head according to claim **[[14]]** 15, wherein said first distance is less than about 95% of said second distance.

19. (Original) A milling head according to claim 15, wherein said first distance is less than about 90% of said second distance.

20. (Cancelled)

21. (New) A milling head for a rotary milling tool, comprising:

a cylindrical body having an annular recess, said body adapted to be connected to a rotary milling tool;

one or more cutting blades connected to said body by a securing element, each said blade disposed circumferentially around the rotational axis of the milling head, each said blade having a cutting edge defining an annular cutting sweep having an inner radius which is adapted to remove an outer radial thickness from an annular tube in an amount of from about 2% up to about 25% of said annular tube thickness, and an outer radius at least equal to said tube outer diameter, wherein said blade has a face surface and an opposite surface with a bore extending therebetween through which said securing element connects said blade to said body, said blade having a countersink around said bore capable of receiving at least a portion of a head of said securing element, and wherein said securing element connects said blade to said body whereby the securing element has a head portion which extends out from said blade face surface a first

distance which is less than or equal to a second distance measured from a lower edge of the securing element head to a lower cutting edge of the blade

22. (New) A milling head according to claim 21, wherein said securing element connects said blade to said body whereby the securing element head portion has an end which is flush mounted or recess mounted in relation to said blade face.